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(54) CLOSURE DEVICE COMPRISING AN OPENING INDICATOR

VERSCHLUSSVORRICHTUNG MIT EINEM ÖFFNUNGSINDIKATOR

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(73) Proprietor: **Betapack, S.A.U.**
20305 Irun, Gipuzkoa (ES)

(72) Inventor: **BERROA GARCÍA, Javier**
20305 Irun, Gipuzkoa (ES)

(74) Representative: **Herrero & Asociados, S.L.**
Edificio Aqua - Agustín de Foxá, 4-10
28036 Madrid (ES)

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Description

Object of the invention

[0001] The present invention relates to the field of container closures and particularly to a closure device indicating that the container has been opened at least once, and to a method of manufacturing such a closure device.

Background of the invention

[0002] There are many circumstances in which it is important to know whether a container or package has been previously opened. This is the case, for example, of containers whose content degrades after the first opening, containers under suspicion of having been adulterated or manipulated for illegal purposes, or just to guarantee consumers that the content of products in general is intact at the time of purchase. In the particular case of closures, various techniques have been developed based on plastic parts that are broken off, detached or change position after a first opening of the container.

[0003] For example, EP 1892194 A1 discloses a closure device comprising a base attached to the container and a lid hinged to the base that partially covers it. The device comprises a first opening indicator attached to the lid by separable connections, which is visible previous to its opening. During the first opening, the stresses performed result in breakage of the connections, so the first opening indicator falls into a housing of the base and is hidden from view of the user. While a user who is familiar with the device may realise that the absence of the indicator means that the package has been opened, a user who has not previously seen the package is likely to overlook this change.

[0004] US 4941592 A shows a second example with a similar technology. In this case, the dispensing device comprises two tabs attached to the lid, which are separated during the first opening, being hidden in respective housings of the base. The tabs are located on both sides of the closure, separated 90° from the hinge allowing the opening thereof. Once again, if the user only sees a container that has been opened, without knowledge of its previous appearance, (s)he is likely to ignore the signs.

[0005] WO 2012/131097 A discloses a closure device according to the preamble of claim 1.

[0006] In short, all the above mentioned solutions have the disadvantage that the signs of opening are inconspicuous once the container is opened. Accordingly, when a user finds an open container, (s)he could overlook the signs, or may need to compare it with another still closed container, which is not always possible. Additionally, the opening signalling devices known may require significant structural changes of the product and result in complicated handling.

[0007] In the state of the art there is, therefore, the need for a closure device that allows the user to know clearly whether a container has been opened and without

the comparison with other units. It is also desirable that the device does not significantly change the container nor relevantly complicate its initial opening, and that the signs be robust and unable to accidentally fall off the container after opening.

Description of the invention

[0008] The present invention solves the problems described above by means of a closure device according to claim 1, that allows a clear visualisation of a detached opening indicator after a first opening.

[0009] The opening indicator is a band with an extended protrusion in radial direction relative to the longitudinal axis. The geometry and size of the protrusion allows for both the partial insertion of the band into the housing through the upper slot and the prevention of its removal once introduced. More preferably, the band is connected to the lid by three equally spaced attachment points. Also preferably, the housing and/or the opening indicator are made of a plastic material which allows sufficient deformation to partially introduce said indicator into the housing during installation or manufacture of the device and to prevent its subsequent accidental removal.

[0010] Preferably, the housing comprises two windows distributed along the perimeter surface of the base in the area occupied by the opening indicator, being separated by a reinforcing structure. The visibility of the indicator is thus maximised after the first opening of the container, at the same time as ensuring that the indicator is not accidentally expelled through the windows.

[0011] Preferably, the attachment between the lid and the base may be reinforced by auxiliary fixing means distributed peripherally, thus ensuring that both elements remain attached despite the movements performed by the hinge. Also preferably, the contact plane between the base and the lid is perpendicular to the longitudinal axis.

[0012] Preferably, the device comprises additional means to enhance the fastening to the container neck, such as an inner thread and/or a second peripheral wall that is fixed inside said neck.

[0013] To ensure that the lid can be closed properly, once broken the attachment points between said lid and the opening indicator that initially fixes it to the base, said base preferably comprises a grip which fixes the lid in the closed position after the first opening. Said grip is therefore located in a diametrically opposite position relative to the hinge axis, the grip being, in any event, easily removable at the user's will.

[0014] Preferably, the attachment between the lid and the base in the area of the hinge is provided by a second housing wherein an extension connected to the hinge is introduced. Also, the morphology of the extension and the second housing allows the insertion of the extension during installation or manufacture of the device, but prevents its subsequent removal. That is, the connection between the lid and the base in the area of the hinge remains fixed regardless of the opening of the device.

[0015] In a second aspect of the invention, a method for manufacturing a closure device, according to claim 15, is provided comprising:

- Molding a lid with a hinge and at least one opening indicator at opposite ends. The opening indicator is attached to the lid by at least one separable connector adapted to be separated from the lid after a first opening. 5
- Molding a base with a first peripheral wall adapted to be outwardly fixed to a neck of a container, and at least a first housing and a second housing at diametrically opposite ends. The first housing is located in a position, which is diametrically opposite to the hinge, and comprises one or more windows. 10
- Introducing a lower end of the opening indicator into an upper slot of the first housing, and an extension of the hinge into the second housing. 15

Preferably, the steps of molding the base and molding the lid are made by injection of plastic material. Note that the materials of the base and the lid may be identical or different. Note also that the method of the invention may comprise molding the lid and/or the base with any of the preferred options and particular modes for carrying out the invention described for the device of the invention. 20

[0016] In short, the device described allows the user to know whether the container has been previously opened clearly and without the need to compare with other states of the container and/or other similar containers. Said information is provided to the user without hindering the initial opening of the device and without substantially changing the morphology or appearance of the container. In addition, the visibility of the opening indicator is maximised while its integrity is guaranteed. Finally, the closure device is easily manufactured and installable and can be made by molding of plastic materials in only two pieces. These and other advantages of the invention will be apparent in the light of its detailed description. 25

Description of the drawings

[0017] In order to assist in a better understanding of the characteristics of the invention according to a preferred exemplary mode for carrying it out and to complement this description, the following figures, of illustrative and not limiting nature, are attached: 30

Figure 1 is a first perspective view of the closure device prior to the first opening, according to a preferred embodiment. 35

Figure 2 is a second perspective view of the closure device prior to the first opening, according to the preferred embodiment. 40

Figure 3 is a frontal view of the closure device prior to the first opening, according to the preferred embodiment. 45

Figure 4 is a sectional view of the closure device

prior to the first opening, according to the preferred embodiment.

Figure 5 is a perspective view of the base of the closure device, according to the preferred embodiment.

Figure 6 is a side view of the base of the closure device, according to the preferred embodiment.

Figure 7 is a sectional view of the base of the closure device, according to the preferred embodiment.

Figure 8 is a perspective view of the lid of the closure device, according to the preferred embodiment.

Figure 9 is a side view of the lid of the closure device, according to the preferred embodiment.

Figure 10 is a sectional view of the lid of the closure device, according to the preferred embodiment.

Figure 11 is a perspective view of the closure device open, according to the preferred embodiment.

Figure 12 is a side view of the closure device open, according to the preferred embodiment.

Figure 13 is a sectional view of the closure device open, according to the preferred embodiment.

Figure 14 is a first perspective view of the closure device, closed after a first opening, according to the preferred embodiment.

Figure 15 is a side view of the closure device, closed after a first opening, according to the preferred embodiment.

Figure 16 is a sectional view of the closure device, closed after a first opening, according to the preferred embodiment. 30

Preferred mode for carrying out the invention

[0018] For better clarity of the description of the preferred modes for carrying out the invention herein will be named "front" the part of the device in which the tamper band is located and, therefore, said tamper band is in direct face to face view. Similarly, herein will be named "back" the part of the device in which the hinge is located and, therefore, said hinge is in direct face to face view. 35

[0019] Figure 1 shows a first perspective view of a preferred mode for carrying out the invention of the closure device wherein can be seen the front thereof prior to the first opening. The device comprises a base 100 and a lid 200, typically made by molding a plastic material. The base 100 comprises a first peripheral wall 101 adapted to surround the outside of the neck of a container. The peripheral wall 101 has rotational symmetry about a longitudinal axis 300. Note, however, that the axis 300 is only defined to facilitate the clarity of the description, so other particular modes for carrying out the peripheral wall 101 can be implemented with alternative geometries. 40

[0020] At its upper front end, the base 100 comprises a first housing 111 with two windows 112 in which an opening indicator 207 is housed after the device is opened for the first time. These windows 112 are separated by a partition 114 or reinforcing structure. Additionally, the base 100 comprises a strip 104 at the lower end 45

of said first peripheral wall 101 which acts as a safety ring. The strip 104 is attached to the lower end of the first peripheral wall 101 by detachable joints 105. Furthermore, said base 100 comprises a plurality of peripherally distributed projections 113 at the upper end of the first peripheral wall 101.

[0021] The lid 200 comprises a top cover 201 which prevents the exit of the content stored in the container, a loop 210 to facilitate opening of said lid 200, and a guiding element 211 in relief indicating the opening direction. The lid 200 further comprises auxiliary fixing means 212 that are introduced into the upper perimeter of the base 100 to maintain the attachment of the device during opening. The auxiliary attachment means may be initially separated from the upper cover 201, or be attached to said upper cover 201 by attachments that are easily broken during the first opening of the device.

[0022] Finally, the lid 200 comprises an opening indicator 207, whose lower end is partially introduced into an upper opening of the first housing 111 of the base 100 during manufacture or installation of the device. Said opening indicator 207 is a band covering an arc of circumference of attachment between the lid 200 and the base 100, initially attached to the lid 200 by a plurality of separable connectors 209. Note that prior to the first opening, the opening indicator is not visible through the windows 112. Note also that the band may comprise any element or additional feature that enhances its visibility once the device is open, such as text or a distinct colour to the first housing 111.

[0023] Figure 2 shows a second perspective view of the same preferred embodiment of the device before the first opening, in this case showing the back of the device. There can be seen the hinge 205 mounted on the body of the lid 200 and the attachment between the auxiliary fixing means 212 and the lower end of said hinge 205. Note that in the present description, hinge 205 means anything that allows articulation of the base 100 and the lid 200, facilitating the relative movement of both elements between a closed position and an open position, and maintaining a point of attachment between the base 100 and the lid 200 throughout the entire process. For example, depending on particular modes for carrying out the invention, the hinge 205 may be a region of the lid in which one or more partial slots are made that allow its articulation, or it may be a separate element connected to the base 100 and the lid 200 by any conventional mechanical technology known in the state of the art.

[0024] Figure 3 is a front view of the same implementation of the closure device described. Note in particular the presence of three separable connectors 209 equidistant between the upper end of the opening indicator 207 and the rest of the lid 200 and detachable joints 105 between the strip 104 and the first peripheral wall 101. The separable connectors 209 are joints of the same plastic material used to implement the lid 200 and the opening indicator 207, but its thickness is so reduced that the stresses caused by the first opening of the device result

in its breakage, separating the lid 200 and the opening indicator 207.

[0025] Figure 4 presents a section of the same embodiment of the closure device on a plane that contains the centre of the hinge 205, the axis 300 and the centre of the opening indicator 207, allowing the internal characteristics of the device and the different attachments between the lid 200 and the base 100 to be seen. Relative to the interior of the base 100, the first peripheral wall 101 comprises in its interior a thread 103 adapted to screw on an additional screw on the outside of the neck of the container. The lower strip 104 comprises, in addition, a plurality of protuberances 106 distributed along its inner perimeter. Furthermore, the base 100 comprises a second peripheral wall 102, concentric to the first peripheral wall 101 and of smaller diameter, which rests on the inner side of the neck, reinforcing the fastening to the container and directing the content of the container towards a nozzle 107, which in this case, stands out from the rest of the base 100. The nozzle 107 comprises one or more openings 108 and a dispenser 115 that controls the output of liquid.

[0026] With regards to the lid 200 it comprises a third peripheral wall 203, concentric to the second peripheral wall 102 and of smaller diameter, adapted to cover the exterior of the nozzle 107; and a fourth peripheral wall 202, concentric to the third peripheral wall 203 and of smaller diameter, adapted to cover the interior of the nozzle 107, thus preventing the exit of the content of the container while the closure device is closed.

[0027] At the lower front end of the nozzle 107 a protuberance or grip 109 is located, which cooperates with a latch 204 on the inner bottom front end of the lid 200 to keep the lid 200 closed at the user's will, even after the opening indicator 207 has been detached. Note that said latch 204 is not fixed, but can be opened by the user easily by applying pressure upwards in the lid 200, for example by pulling the loop 210. At the end, which is diametrically opposite to said loop 109 with respect to the axis 300, the fixation of the hinge 205 and the base 100 is carried out. Such fixation is permanent, i.e., it is maintained both in an open and a closed position, and is made through introduction of a hinge 205 extension 206 into a second housing 110. Both the extension 206 and the second housing 110 comprise wedge shaped protuberances that allow for the introduction of the elements but not their removal.

[0028] Equivalently, the opening indicator 207 comprises a protuberance 208, which protrudes in radial direction with respect to the axis 300. The lower side of the protuberance 208 is, at least in part, wedge-shaped, while the upper side of the protuberance 208 is mostly flat. Thanks to this morphology, the opening indicator 207 can be introduced into the first housing 111 during installation or manufacture of the device, while the removal of said opening indicator 207 during the operation of the device is prevented.

[0029] All elements and features of the described pre-

ferred embodiment can be seen in greater detail in Figures 5 to 10, which present the base 100 and the lid 200 separately. In particular, Figure 5 is a perspective view of the front of the base 100, Figure 6 is a side view of the base 100 and Figure 7 is a sectional view of the base 100 in the same cutting plane of the Figure 4. On the other hand, Figure 8 is a perspective view of the front of the base 200, Figure 9 is a side view of the base 200 and Figure 10 is a sectional view of the base 200 in the same cutting plane of the Figure 4.

[0030] Figure 11 shows the state of the same embodiment of the closing device after a first opening thereof. Due to the stress exerted to open the lid 200, the separable connectors 209 are broken, shedding the opening indicator 207. Said opening indicator 207 is received by the first housing 111, being visible to the user through the windows 112. The separation or reinforcing structure 114, the size of the windows 112 and the protuberance 208 of the opening indicator 207 ensure that said opening indicator 207 does not leave the first housing 111 regardless of subsequent movements of the container and the closure device.

[0031] Figures 12 and 13 show, respectively, a side view and a section of the same embodiment and in the same position as in Figure 11. Note in particular the position of the hinge 205, whose partial slots in its top and bottom ends allow the articulation of the lid 200 by deforming only the region of said slots.

[0032] Finally, Figure 14 shows the state of the same embodiment of the closing device after, at least, one opening and closing. Figures 15 and 16 show, respectively, a side view and a section of the same embodiment and in the same position as in Figure 14.

[0033] After closing, the lid 200 returns to its original position, remaining fixed to the base 100 by the previously described connections. The only difference with respect to the initial position prior to the first opening is that the opening indicator 207 remains detached after breakage of the detachable connectors 209, said opening indicator 207 being shown through the windows 112. That is, the closure device continues to fulfil its function of keeping the contents inside the container, but the user can clearly see that the container has been opened at least once without having to compare it with other similar units. This makes for a clear, intuitive, secure and robust sign; without interfering at any time with normal operation of the closure device.

[0034] In view of this description and Figures, the person skilled in the art will understand that the invention has been described according to preferred embodiments thereof, but that multiple variations can be introduced in said preferred embodiments without departing from the object of the invention as has been claimed. For example, an embodiment has been presented in two parts with the articulation element integrated at the top. However, other embodiments may implement the functions described by a larger number of pieces connected together, or with alternative distributions of functionality between the two

pieces, such as integrating the articulation element at the base. Similarly, the base and/or lid may have different morphologies to adapt to the morphology of the container to be covered, always maintaining the elements and functionalities claimed.

Claims

1. A closing device comprising:

- a base (100) with a first peripheral wall (101) adapted to be fixed externally to a neck of a container, and said first peripheral wall (101) defining a central longitudinal axis (300);
- a lid (200) hinged to the base (100) by a hinge (205);
- at least one opening indicator (207) connected to the lid (200) by at least one separable connector (209) prior to a first opening, said opening indicator (207) being separated from the lid (200) after said first opening;
- at its upper front end, the base (100) comprises at least one first housing (111) with at least one window (112), said at least one first housing (111) receiving the at least one opening indicator (207) after the first opening and showing said at least one opening indicator (207) through the at least one window;

characterised in that:

- the first housing (111) is located in a position diametrically opposite the hinge (205) with respect to the axis (300);
- the closing device is configured such that due to the stress exerted to open the lid (200), the at least one separable connector (209) is broken, shedding the opening indicator (207), wherein said opening indicator (207) is received by the at least one first housing (111), being visible to the user through the at least one window (112); wherein prior to the first opening, the opening indicator (207) is not visible through the at least one window (112); wherein after the first opening and closing, the opening indicator (207) remains detached after breakage of the separable connectors (209), said opening indicator (207) being shown through the at least one window (112);

and wherein the at least one opening indicator (207) is a band with at least one protuberance (208) in radial direction with respect to the central longitudinal axis (300), said protuberance (208) allowing the band to be inserted in the at least one first housing (111) and preventing the removal of said band from

the at least one first housing (111).

2. The device according to Claim 1, **characterised in that** the separable connectors (209) comprise at least three attachment points equally spaced along the band. 5
3. The device according to any of the preceding claims, **characterised in that** the at least one first housing (111) comprises at least two windows (112) distributed in peripheral direction with respect to the central longitudinal axis (300), the at least two windows (112) remaining separated by at least one reinforcing structure (114). 10
4. The device according to any of the preceding claims, **characterised in that** the lid (200) further comprises auxiliary attachment means (212) peripherally distributed with respect to the central longitudinal axis (300), said auxiliary attachment means (212) connecting the lid (200) to the base (100) regardless of the relative movement between said lid (200) and said base (100) caused by the hinge (205). 15
5. The device according to any of the preceding claims, **characterised in that** the at least one opening indicator (207) is of a deformable plastic material which allows said at least one opening indicator (207) to be inserted into the at least one first housing (111). 20
6. The device according to any of the preceding claims, **characterised in that** the at least one first housing (111) is of a deformable plastic material which allows the insertion of the at least one opening indicator (207) into the at least one first housing (111). 25
7. The device according to any of the preceding claims, **characterised in that** the main plane of contact between the base (100) and the lid (200) is perpendicular to the central longitudinal axis (300). 30
8. The device according to any of the preceding claims, **characterised in that** the first peripheral wall (101) comprises an inner thread (103). 35
9. The device according to any of the preceding claims, **characterised in that** it comprises a second peripheral wall (102) adapted to be fixed inwardly to the neck of the container. 40
10. The device according to any of the preceding claims, **characterised in that** the base (100) comprises a grip (109) in a position diametrically opposite to the hinge (205) with respect to the central longitudinal axis (300), said grip (109) maintaining the lid (200) closed subsequent to the first opening. 45
11. The device according to any of the preceding claims,

characterised in that the base (100) comprises a second housing (110) in a position diametrically opposite to the at least one first housing (111) with respect to the axis (300), and **in that** the lid (200) comprises an extension (206) connected to the hinge (205), the second housing (110) allowing the extension (206) to be inserted and preventing the removal of said extension (206).

12. The device according to any of the preceding claims, **characterised in that** the at least one separable connector (209) is a joint of a same material as the at least one opening indicator (207), the joint having a thickness that causes the breakage of said joint under a lesser force than that required to remove the at least one separable connector (209) from the at least one first housing (111). 50
13. The device according to claim 9, **characterised in that** the lid (200) comprises a third peripheral wall (203), concentric to the second peripheral wall (102) and of smaller diameter, adapted to cover the exterior of the nozzle (107); and a fourth peripheral wall (202), concentric to the third peripheral wall (203) and of smaller diameter, adapted to cover the interior of a nozzle (107). 55
14. The device according to claim 1, **characterised in that** the protuberance (208) protrudes in radial direction with respect to the central longitudinal axis (300), wherein the lower side of the protuberance (208) is, at least in part, wedge-shaped, while the upper side of the protuberance (208) is mostly flat.
15. A method of manufacturing a closure device according to any of the preceding claims, **characterised in that** it comprises:
 - molding a lid (200) with a hinge (205) and at least one opening indicator (207) connected to the lid (200) by at least one separable connector (209) adapted to be separated from the lid (200) after a first opening;
 - molding a base (100) with a first peripheral wall (101) adapted to be fixed externally to a neck of a container, at least one first housing (111) with at least one window (112), and a second housing; the first housing (111) being located in a position diametrically opposite the hinge (205) with respect to a central longitudinal axis (300) defined by the first peripheral wall (101); and
 - introducing a lower end of the opening indicator (207) into an upper slot of the first housing (111), and an extension (206) of the hinge (205) into the second housing (110);
 wherein the steps of molding the lid (200) and molding the base (100) are made by injection of at least one plastic material;

wherein prior to the first opening, the opening indicator (207) is not visible through the at least one window (112);
 and wherein after the first opening and closing, the opening indicator (207) remains detached after breakage of the separable connectors (209), said opening indicator (207) being shown through the at least one window (112).

Patentansprüche

1. Verschlussvorrichtung, umfassend:

- eine Basis (100) mit einer ersten Umfangswand (101), die dazu geeignet ist, außen an einem Hals eines Behälters befestigt zu werden, wobei die erste Umfangswand (101) eine zentrale Längsachse (300) definiert;
- einen Deckel (200), der über ein Scharnier (205) an der Basis (100) angelenkt ist;
- mindestens einen Öffnungsanzeiger (207), der mit dem Deckel (200) durch mindestens einen trennbaren Verbinder (209) vor einer ersten Öffnung verbunden ist, wobei der Öffnungsanzeiger (207) nach der ersten Öffnung vom Deckel (200) getrennt ist;
- die Basis (100) an ihrem oberen vorderen Ende mindestens ein erstes Gehäuse (111) mit mindestens einem Fenster (112) umfasst, wobei das mindestens eine erste Gehäuse (111) den mindestens einen Öffnungsanzeiger (207) nach dem ersten Öffnen aufnimmt und den mindestens einen Öffnungsanzeiger (207) durch das mindestens eine Fenster zeigt;

dadurch gekennzeichnet, dass:

- das erste Gehäuse (111) sich in einer Position befindet, die dem Scharnier (205) in Bezug auf die Achse (300) diametral gegenüberliegt;
- die Verschlussvorrichtung so konfiguriert ist, dass aufgrund der zum Öffnen des Deckels (200) ausgeübten Spannung der mindestens eine trennbare Verbinder (209) gebrochen wird, wodurch der Öffnungsanzeiger (207) freigegeben wird, wobei der Öffnungsanzeiger (207) von dem mindestens einen ersten Gehäuse (111) aufgenommen wird und für den Benutzer durch das mindestens eine Fenster (112) sichtbar ist; wobei vor dem ersten Öffnen der Öffnungsanzeiger (207) nicht durch das mindestens eine Fenster (112) sichtbar ist; wobei nach dem ersten Öffnen und Schließen der Öffnungsanzeiger (207) nach dem Bruch der trennbaren Verbinder (209) gelöst bleibt, wobei der Öffnungsanzeiger

(207) durch das mindestens eine Fenster (112) gezeigt ist;

und wobei der mindestens eine Öffnungsanzeiger (207) ein Band mit mindestens einer Ausstülpung (208) in radialer Richtung in Bezug auf die zentrale Längsachse (300) ist, wobei die Ausstülpung (208) das Einführen des Bandes in das mindestens eine erste Gehäuse (111) ermöglicht und das Entfernen des Bandes aus dem mindestens einen ersten Gehäuse (111) verhindert.

2. Vorrichtung nach Anspruch 1, **dadurch gekennzeichnet, dass** die trennbaren Verbinder (209) mindestens drei entlang des Bandes gleichmäßig beabstandete Befestigungspunkte aufweisen.

3. Vorrichtung nach einem der vorhergehenden Ansprüche, **dadurch gekennzeichnet, dass** das mindestens eine erste Gehäuse (111) mindestens zwei Fenster (112) aufweist, die in Umfangsrichtung in Bezug auf die zentrale Längsachse (300) verteilt sind, wobei die mindestens zwei Fenster (112) durch mindestens eine Verstärkungsstruktur (114) getrennt bleiben.

4. Vorrichtung nach einem der vorhergehenden Ansprüche, **dadurch gekennzeichnet, dass** der Deckel (200) außerdem Hilfsbefestigungsmittel (212) umfasst, die in Bezug auf die zentrale Längsachse (300) am Umfang verteilt sind, wobei die Hilfsbefestigungsmittel (212) den Deckel (200) mit der Basis (100) unabhängig von der durch das Scharnier (205) verursachten Relativbewegung zwischen dem Deckel (200) und der Basis (100) verbinden.

5. Vorrichtung nach einem der vorhergehenden Ansprüche, **dadurch gekennzeichnet, dass** der mindestens eine Öffnungsanzeiger (207) aus einem verformbaren Kunststoffmaterial besteht, das es ermöglicht, den mindestens einen Öffnungsanzeiger (207) in das mindestens eine erste Gehäuse (111) einzusetzen.

6. Vorrichtung nach einem der vorhergehenden Ansprüche, **dadurch gekennzeichnet, dass** das mindestens eine erste Gehäuse (111) aus einem verformbaren Kunststoffmaterial besteht, das das Einsetzen des mindestens einen Öffnungsanzeigers (207) in das mindestens eine erste Gehäuse (111) ermöglicht.

7. Vorrichtung nach einem der vorhergehenden Ansprüche, **dadurch gekennzeichnet, dass** die Hauptkontaktebene zwischen der Basis (100) und dem Deckel (200) senkrecht zur zentralen Längsachse (300) verläuft.

8. Vorrichtung nach einem der vorhergehenden Ansprüche, **dadurch gekennzeichnet, dass** die erste Umfangswand (101) ein Innengewinde (103) aufweist.
9. Vorrichtung nach einem der vorhergehenden Ansprüche, **dadurch gekennzeichnet, dass** sie eine zweite Umfangswand (102) umfasst, die so angepasst ist, dass sie nach innen am Hals des Behälters befestigt werden kann.
10. Vorrichtung nach einem der vorhergehenden Ansprüche, **dadurch gekennzeichnet, dass** die Basis (100) einen Griff (109) in einer Position diametral gegenüber dem Scharnier (205) in Bezug auf die zentrale Längsachse (300) aufweist, wobei der Griff (109) den Deckel (200) im Anschluss an die erste Öffnung geschlossen hält.
11. Vorrichtung nach einem der vorhergehenden Ansprüche, **dadurch gekennzeichnet, dass** die Basis (100) ein zweites Gehäuse (110) in einer Position diametral gegenüberliegend dem mindestens einen ersten Gehäuse (111) in Bezug auf die Achse (300) umfasst und dass der Deckel (200) eine mit dem Scharnier (205) verbundene Verlängerung (206) aufweist, wobei das zweite Gehäuse (110) das Einsetzen der Verlängerung (206) ermöglicht und das Entfernen der Verlängerung (206) verhindert.
12. Vorrichtung nach einem der vorhergehenden Ansprüche, **dadurch gekennzeichnet, dass** der mindestens eine trennbare Verbinder (209) eine Verbindungsstelle aus dem gleichen Material wie der mindestens eine Öffnungsanzeiger (207) ist, wobei die Verbindungsstelle eine Dicke aufweist, die den Bruch der Verbindungsstelle unter einer geringeren Kraft als derjenigen verursacht, die erforderlich ist, um den mindestens einen trennbaren Verbinder (209) von dem mindestens einen ersten Gehäuse (111) zu entfernen.
13. Vorrichtung nach Anspruch 9, **dadurch gekennzeichnet, dass** der Deckel (200) eine dritte Umfangswand (203), die konzentrisch zur zweiten Umfangswand (102) ist und einen geringeren Durchmesser aufweist, die geeignet ist, die Außenseite der Düse (107) abzudecken; und eine vierte Umfangswand (202) umfasst, die konzentrisch zur dritten Umfangswand (203) ist und einen geringeren Durchmesser aufweist, die geeignet ist, das Innere einer Düse (107) abzudecken.
14. Vorrichtung nach Anspruch 1, **dadurch gekennzeichnet, dass** die Ausstülpung (208) in radialer Richtung in Bezug auf die zentrale Längsachse (300) vorsteht, wobei die Unterseite der Ausstülpung (208) zumindest teilweise keilförmig ist, während die Ober-

seite der Ausstülpung (208) überwiegend flach ist.

15. Verfahren zur Herstellung einer Verschlussvorrichtung nach einem der vorhergehenden Ansprüche, **dadurch gekennzeichnet, dass** es umfasst:

- Formen eines Deckels (200) mit einem Scharnier (205) und mindestens einem Öffnungsanzeiger (207), der mit dem Deckel (200) durch mindestens einen trennbaren Verbinder (209) verbunden ist, der angepasst ist, nach einer ersten Öffnung vom Deckel (200) getrennt zu werden;
 - Formen einer Basis (100) mit einer ersten Umfangswand (101), die geeignet ist, außen an einem Hals eines Behälters befestigt zu werden, mindestens einem ersten Gehäuse (111) mit mindestens einem Fenster (112) und einem zweiten Gehäuse; wobei sich das erste Gehäuse (111) in einer Position diametral gegenüber dem Scharnier (205) in Bezug auf eine zentrale Längsachse (300) befindet, die durch die erste Umfangswand (101) definiert ist; und
 - Einführen eines unteren Endes des Öffnungsanzeigers (207) in einen oberen Schlitz des ersten Gehäuses (111) und einer Verlängerung (206) des Scharniers (205) in das zweite Gehäuse (110);
- wobei die Schritte zum Formen des Deckels (200) und zum Formen der Basis (100) durch Einspritzen von mindestens einem Kunststoffmaterial ausgeführt werden;
- wobei vor dem ersten Öffnen der Öffnungsanzeiger (207) nicht durch das mindestens eine Fenster (112) sichtbar ist;
- und wobei nach dem ersten Öffnen und Schließen der Öffnungsanzeiger (207) nach dem Bruch der trennbaren Verbinder (209) gelöst bleibt, wobei der Öffnungsanzeiger (207) durch das mindestens eine Fenster (112) gezeigt ist.

Revendications

1. Dispositif de fermeture comprenant :

- une base (100) pourvue d'une première paroi périphérique (101) adaptée pour être extérieurement fixée à un col d'un contenant, et ladite première paroi périphérique (101) définissant un axe longitudinal central (300),
- un couvercle (200) s'articulant sur la base (100) par une charnière (205),
- au moins un indicateur d'ouverture (207) raccordé au couvercle (200) par au moins un raccord séparable (209) avant une première ouverture, ledit indicateur d'ouverture (207) étant séparé du couvercle (200) après ladite première

ouverture et

- à son extrémité supérieure avant, la base (100) comprend au moins un premier logement (111) pourvu d'au moins une fenêtre (112), ledit au moins un premier logement (111) recevant l'au moins un indicateur d'ouverture (207) après la première ouverture et montrant ledit au moins un indicateur d'ouverture (207) à travers l'au moins une fenêtre,

caractérisé en ce que

- le premier logement (111) est situé dans une position diamétralement opposée à la charnière (205) par rapport à l'axe (300) et
- le dispositif de fermeture est conçu de telle sorte qu'en raison de la contrainte exercée pour ouvrir le couvercle (200), l'au moins un raccord séparable (209) se casse, lâchant l'indicateur d'ouverture (207), ledit indicateur d'ouverture (207) étant reçu par l'au moins un premier logement (111) qui est visible pour l'utilisateur à travers l'au moins une fenêtre (112),

dans lequel, avant la première ouverture, l'indicateur d'ouverture (207) n'est pas visible à travers l'au moins une fenêtre (112),

dans lequel, après la première ouverture et fermeture, l'indicateur d'ouverture (207) reste détaché après la cassure des raccords séparables (209), ledit indicateur d'ouverture (207) étant montré à travers l'au moins une fenêtre (112) et dans lequel l'au moins un indicateur d'ouverture (207) est une bande pourvue d'au moins une saillie (208) dans une direction radiale par rapport à l'axe longitudinal central (300), ladite saillie (208) permettant à la bande d'être insérée dans l'au moins un premier logement (111) et empêchant le retrait de ladite bande de l'au moins un premier logement (111).

2. Dispositif selon la revendication 1, **caractérisé en ce que** les raccords séparables (209) comprennent au moins trois points de fixation espacés de manière égale le long de la bande.
3. Dispositif selon l'une quelconque des revendications précédentes, **caractérisé en ce que** l'au moins un premier logement (111) comprend au moins deux fenêtres (112) réparties dans une direction périphérique par rapport à l'axe longitudinal central (300), les au moins deux fenêtres (112) restant séparées par au moins une structure de renforcement (114).
4. Dispositif selon l'une quelconque des revendications précédentes, **caractérisé en ce que** le couvercle (200) comprend en outre des moyens de fixation auxiliaires (212) répartis de manière périphérique

par rapport à l'axe longitudinal central (300), lesdits moyens de fixation auxiliaires (212) raccordant le couvercle (200) à la base (100) quel que soit le déplacement relatif entre ledit couvercle (200) et ladite base (100) provoqué par la charnière (205).

5. Dispositif selon l'une quelconque des revendications précédentes, **caractérisé en ce que** l'au moins un indicateur d'ouverture (207) est fait d'un matériau plastique déformable qui permet audit au moins un indicateur d'ouverture (207) d'être inséré dans l'au moins un premier logement (111).
6. Dispositif selon l'une quelconque des revendications précédentes, **caractérisé en ce que** l'au moins un premier logement (111) est fait d'un matériau plastique déformable qui permet d'insertion de l'au moins un indicateur d'ouverture (207) dans l'au moins un premier logement (111).
7. Dispositif selon l'une quelconque des revendications précédentes, **caractérisé en ce que** le plan de contact principal entre la base (100) et le couvercle (200) est perpendiculaire à l'axe longitudinal central (300).
8. Dispositif selon l'une quelconque des revendications précédentes, **caractérisé en ce que** la première paroi périphérique (101) comprend un filetage intérieur (103).
9. Dispositif selon l'une quelconque des revendications précédentes, **caractérisé en ce qu'il** comprend une deuxième paroi périphérique (102) adaptée pour être intérieurement fixée au col du contenant.
10. Dispositif selon l'une quelconque des revendications précédentes, **caractérisé en ce que** la base (100) comprend une partie de préhension (109) dans une position diamétralement opposée à la charnière (205) par rapport à l'axe longitudinal central (300), ladite partie de préhension (109) maintenant le couvercle (200) fermé à la suite de la première ouverture.
11. Dispositif selon l'une quelconque des revendications précédentes, **caractérisé en ce que** la base (100) comprend un second logement (110) dans une position diamétralement opposée à l'au moins un premier logement (111) par rapport à l'axe (300), et **en ce que** le couvercle (200) comprend une extension (206) raccordée à la charnière (205), le second logement (110) permettant à l'extension (206) d'être insérée et empêchant le retrait de ladite extension (206).
12. Dispositif selon l'une quelconque des revendications précédentes, **caractérisé en ce que** l'au moins un raccord séparable (209) est un joint fait d'un même

matériau que l'au moins un indicateur d'ouverture (207), ce joint ayant une épaisseur qui provoque la cassure dudit joint sous une force moindre que celle nécessaire pour retirer l'au moins un raccord séparable (209) de l'au moins un premier logement (111).

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étant montré à travers l'au moins une fenêtre (112).

13. Dispositif selon la revendication 9, **caractérisé en ce que** le couvercle (200) comprend une troisième paroi périphérique (203) concentrique à la deuxième paroi périphérique (102) et d'un diamètre plus petit, adaptée pour couvrir l'extérieur de la buse (107), et une quatrième paroi périphérique (202) concentrique à la troisième paroi périphérique (203) et d'un diamètre plus petit, adaptée pour couvrir l'intérieur de la buse (107).
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- 15
14. Dispositif selon la revendication 1, **caractérisé en ce que** la saillie (208) fait saillie dans une direction radiale par rapport à l'axe longitudinal central (300), dans lequel le côté inférieur de la saillie (208) est au moins en partie cunéiforme tandis que le côté supérieur de la saillie (208) est essentiellement plat.
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15. Procédé de fabrication d'un dispositif de fermeture selon l'une quelconque des revendications précédentes, **caractérisé en ce qu'il** comprend
- 25
- le moulage d'un couvercle (200) avec une charnière (205) et au moins un indicateur d'ouverture (207) raccordé au couvercle (200) par au moins un raccord séparable (209) adapté pour être séparé du couvercle (200) après une première ouverture,
 - le moulage d'une base (100) avec une première paroi périphérique (101) adaptée pour être extérieurement fixée à un col d'un contenant, au moins un premier logement (111) pourvu d'au moins une fenêtre (112) et un second logement, le premier logement (111) étant situé dans une position diamétralement opposée à la charnière (205) par rapport à un axe longitudinal central (300) défini par la première paroi périphérique (101), et
 - l'introduction d'une extrémité inférieure de l'indicateur d'ouverture (207) dans une fente supérieure du premier logement (111), et d'une extension (206) de la charnière (205) dans le second logement (110),
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- selon lequel les étapes de moulage du couvercle (200) et de moulage de la base (100) sont réalisées par injection d'au moins un matériau plastique,
- selon lequel, avant la première ouverture, l'indicateur d'ouverture (207) n'est pas visible à travers l'au moins une fenêtre (112)
- et selon lequel l'indicateur d'ouverture (207) reste détaché après la cassure des raccords séparables (209), ledit indicateur d'ouverture (207)

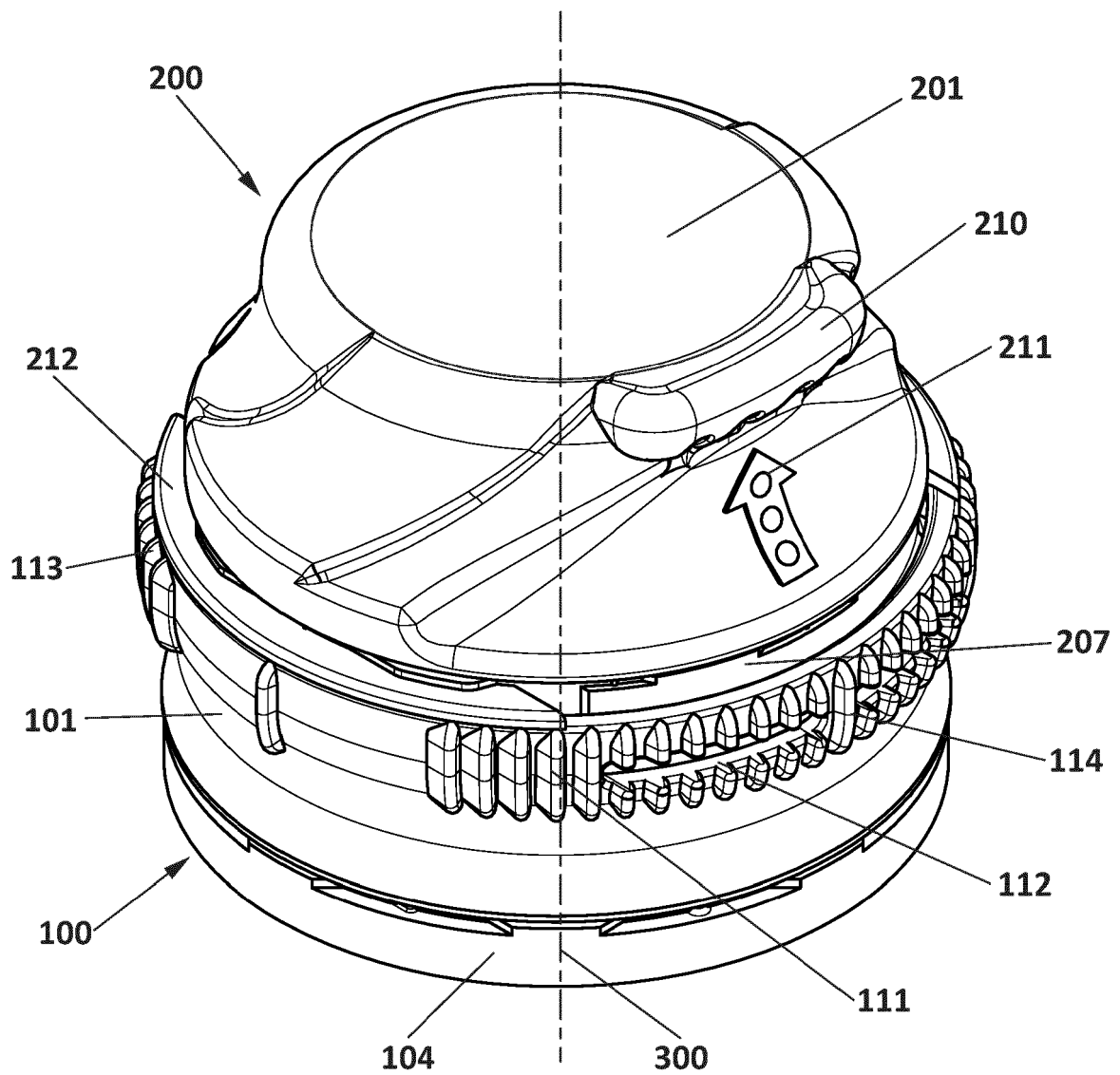


FIG. 1

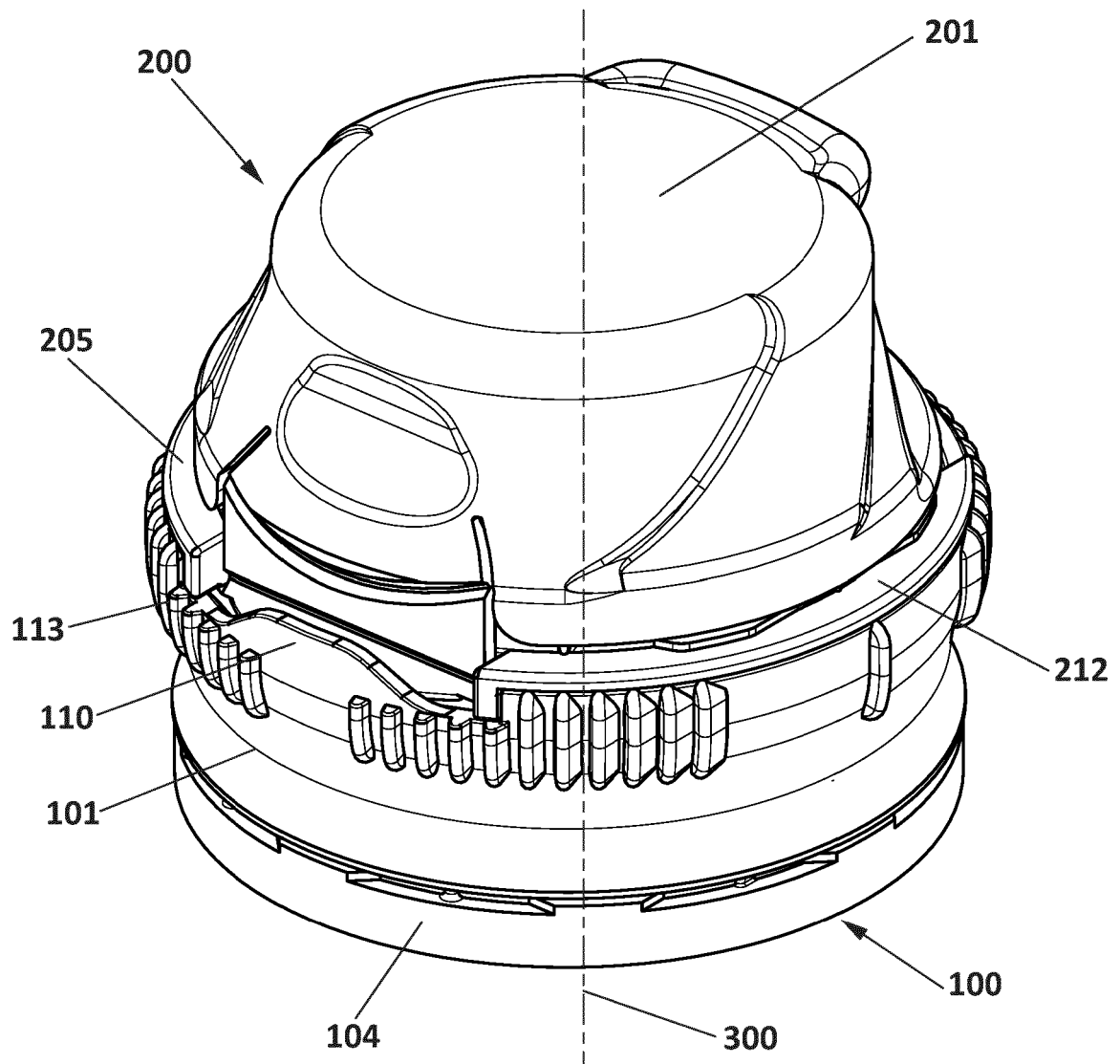
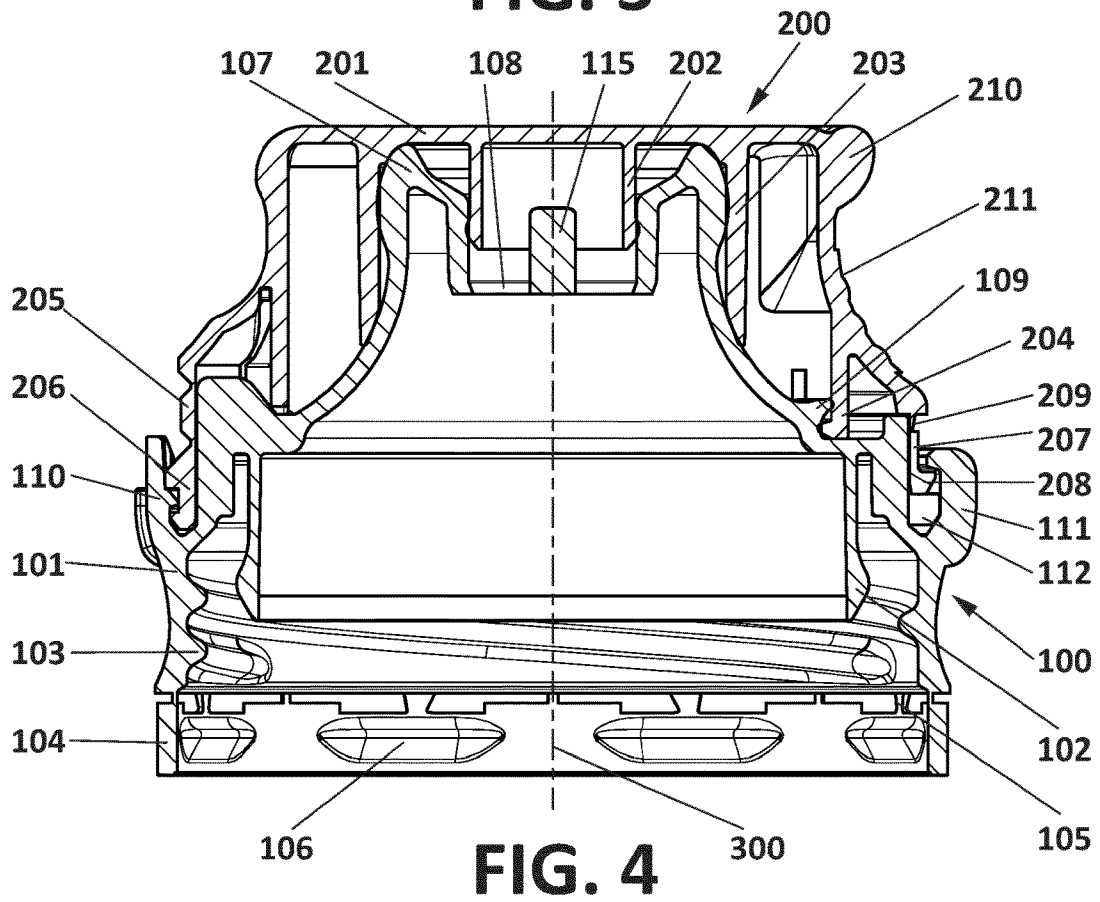
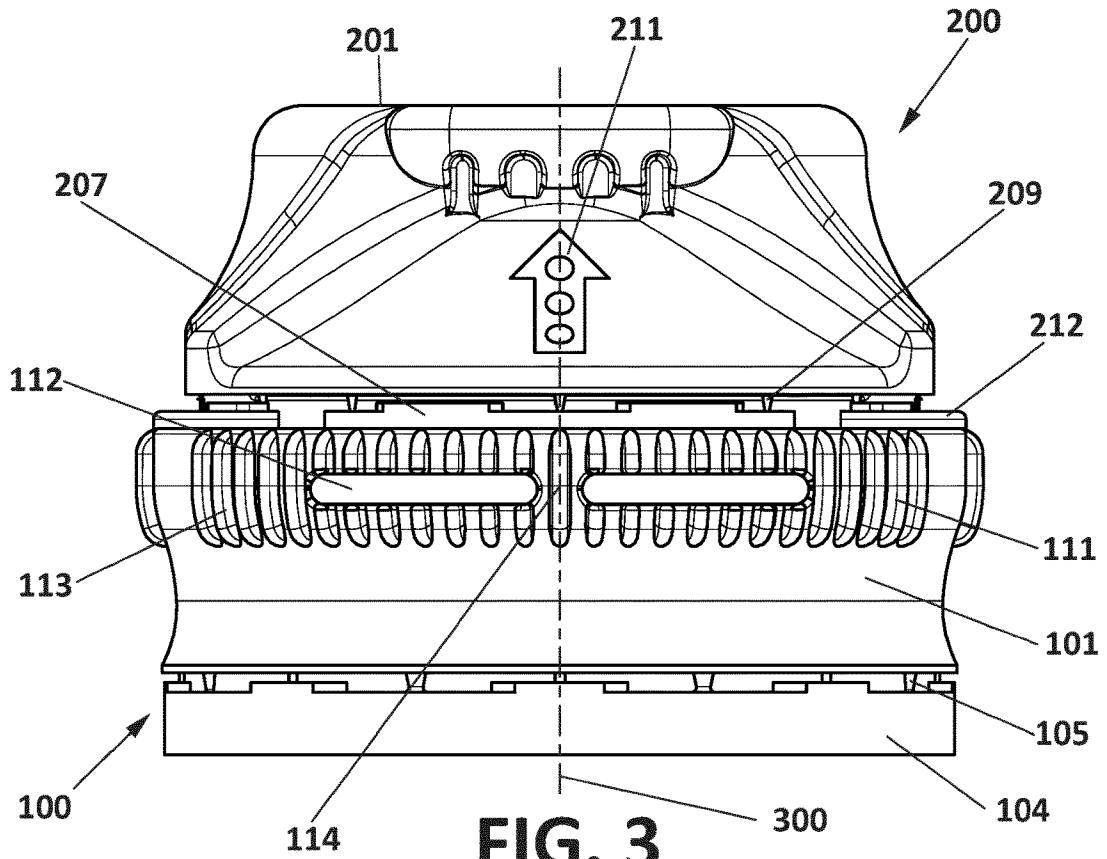


FIG. 2



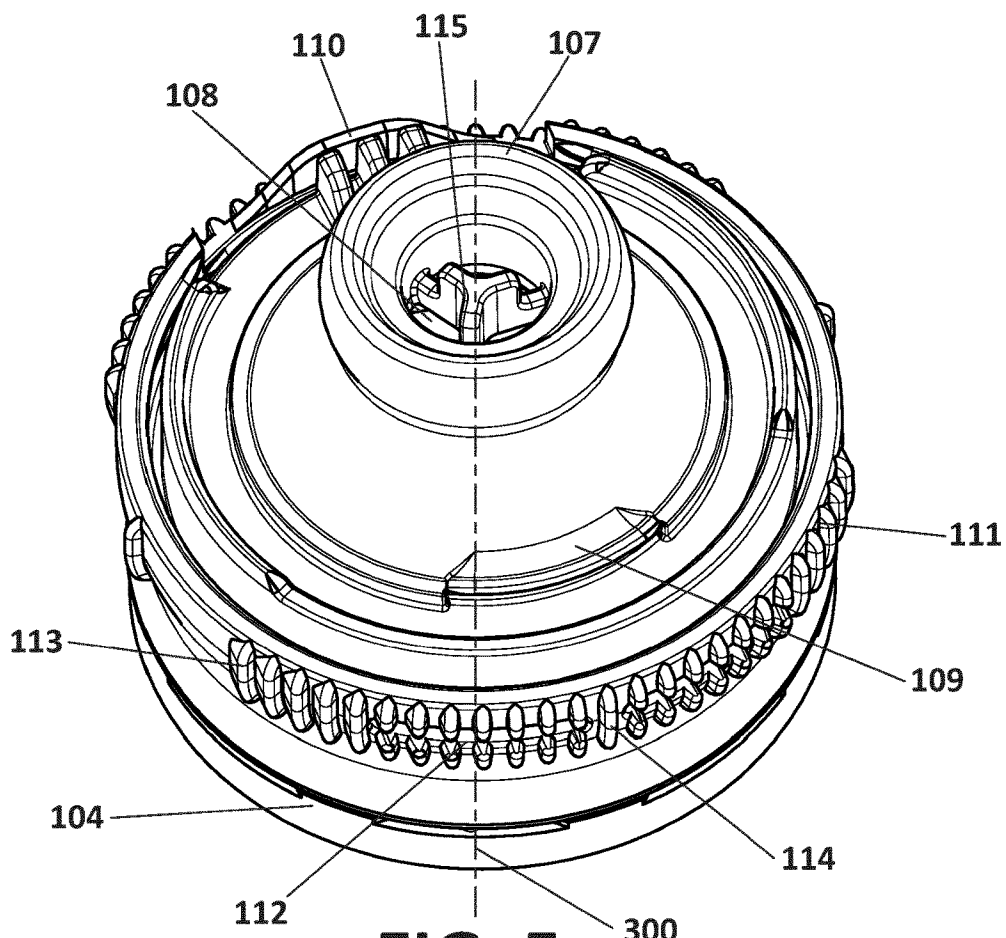


FIG. 5

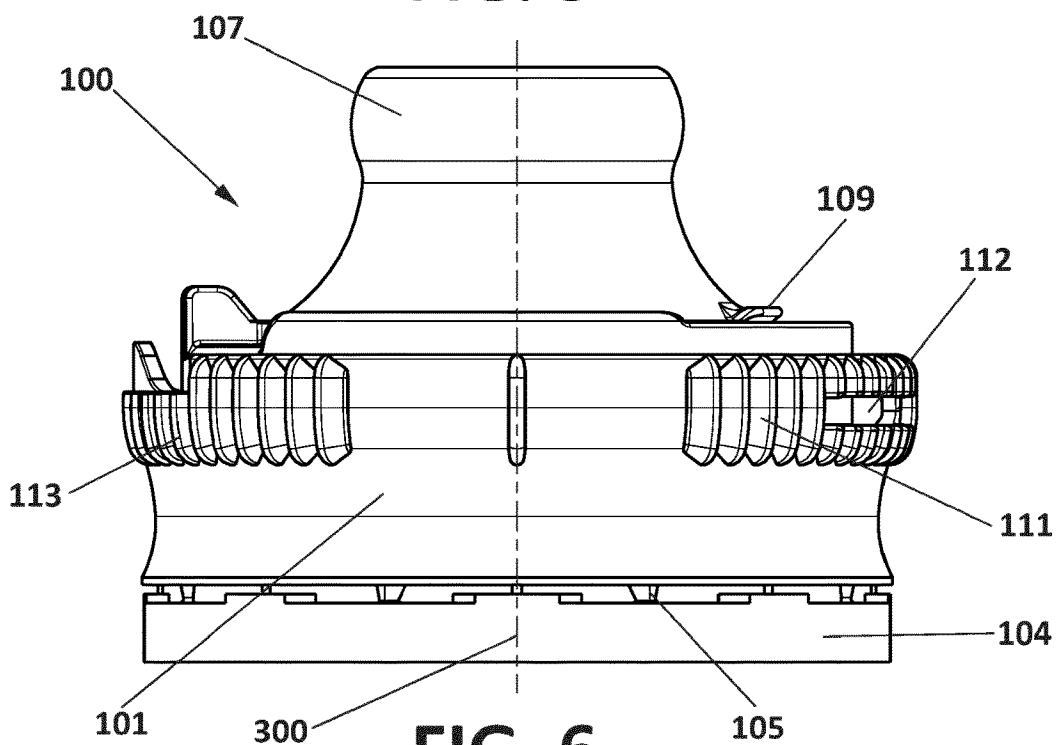
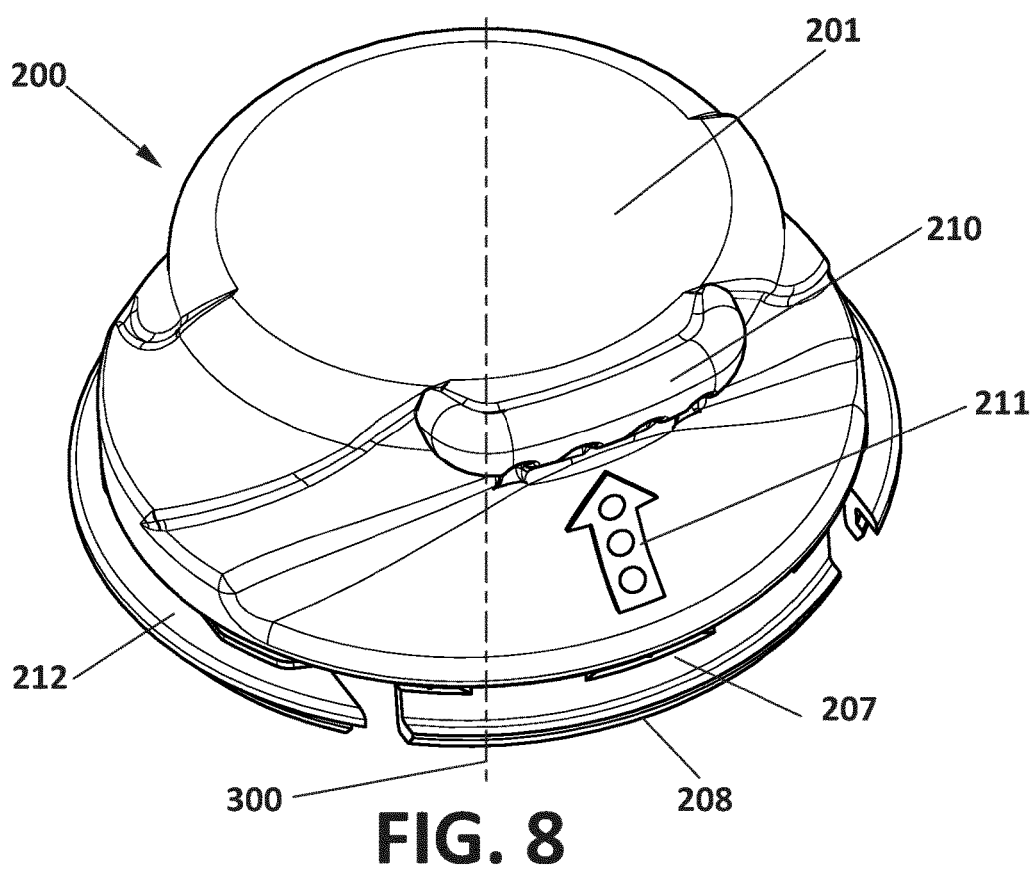
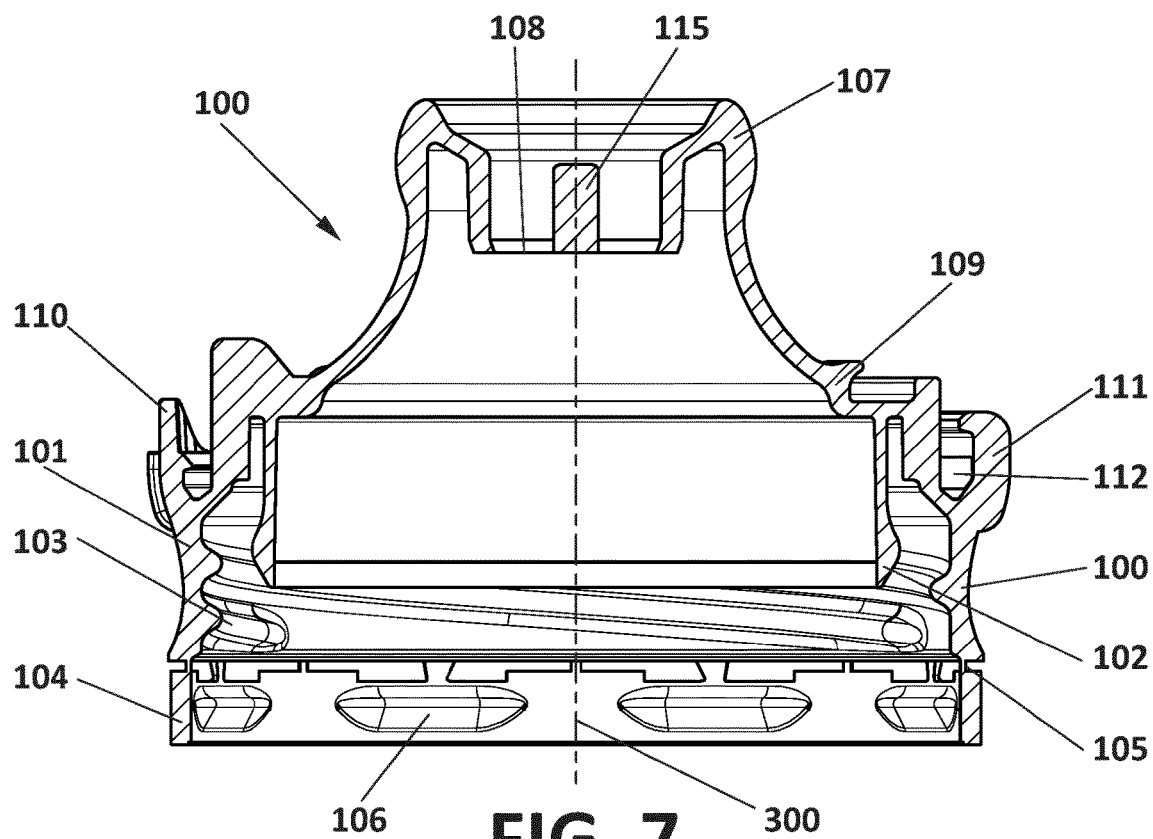


FIG. 6



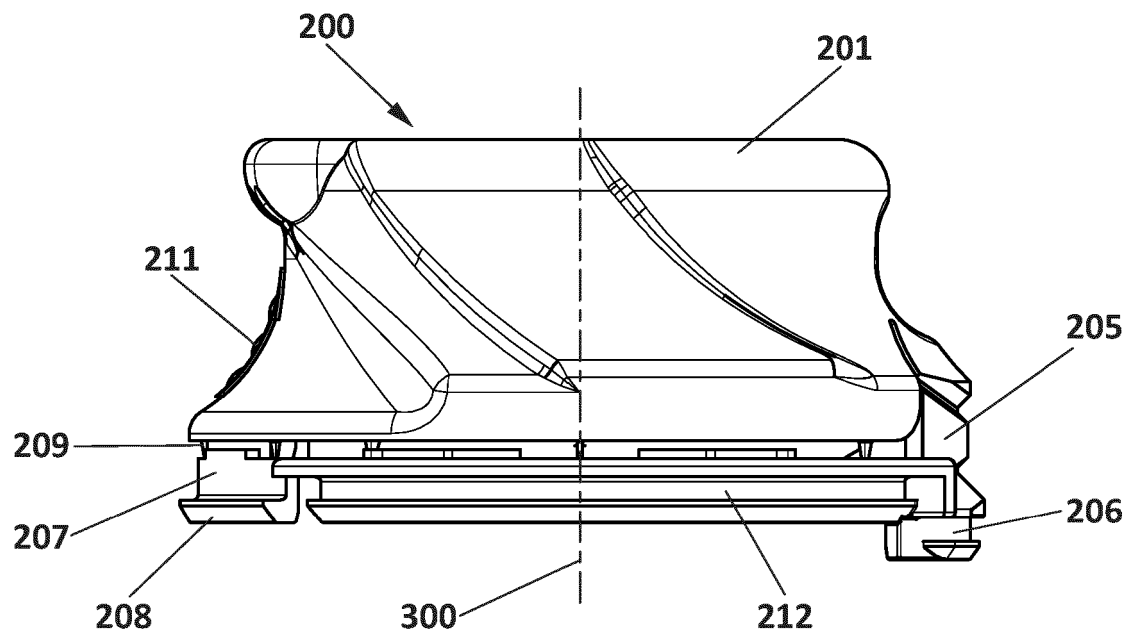


FIG. 9

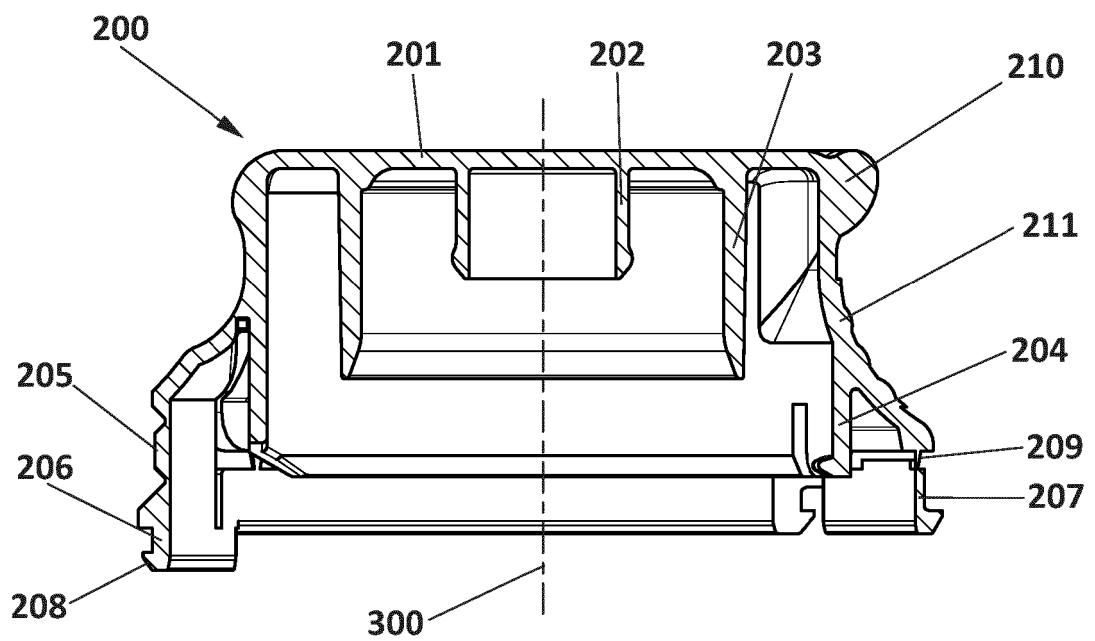
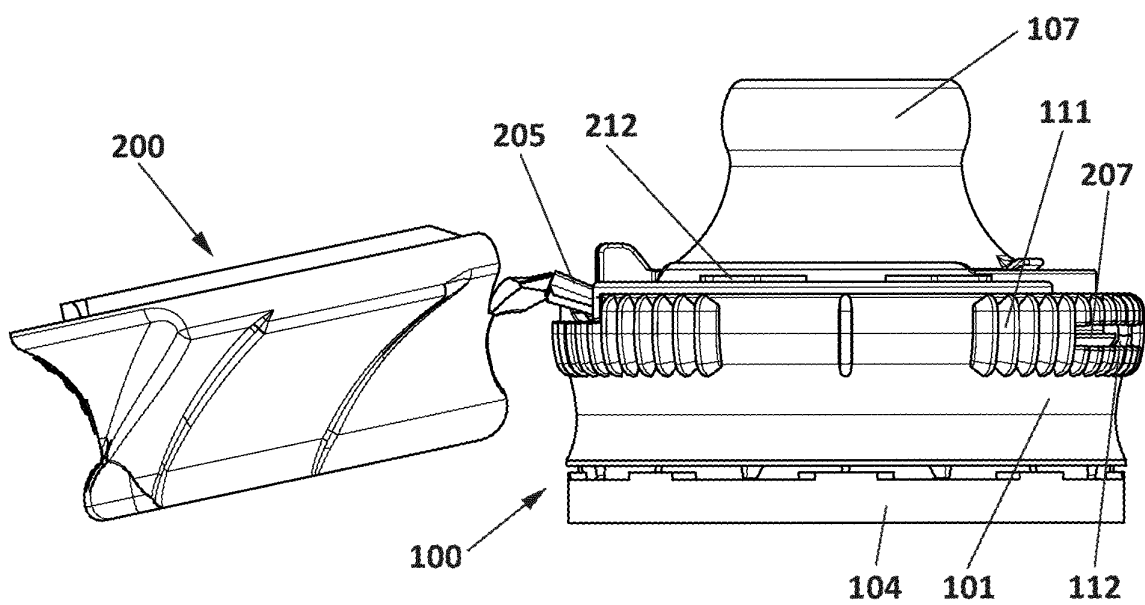
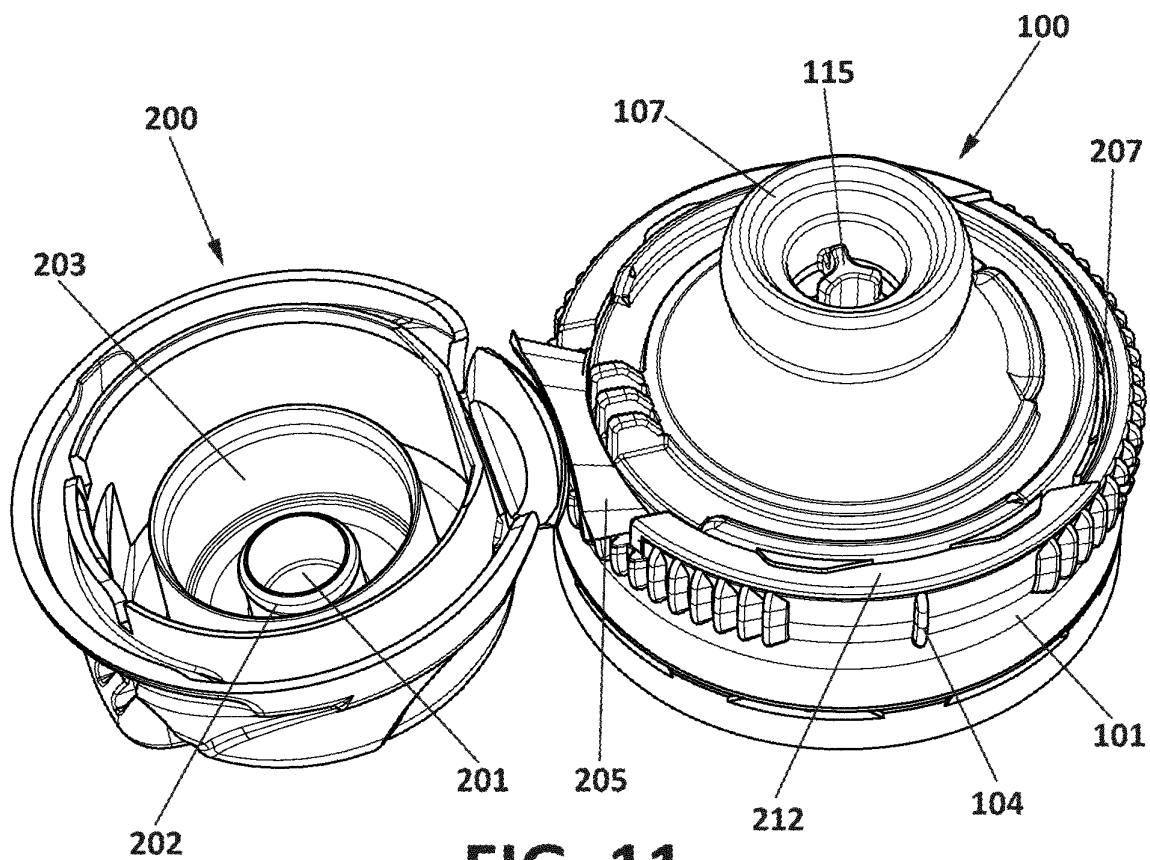


FIG. 10



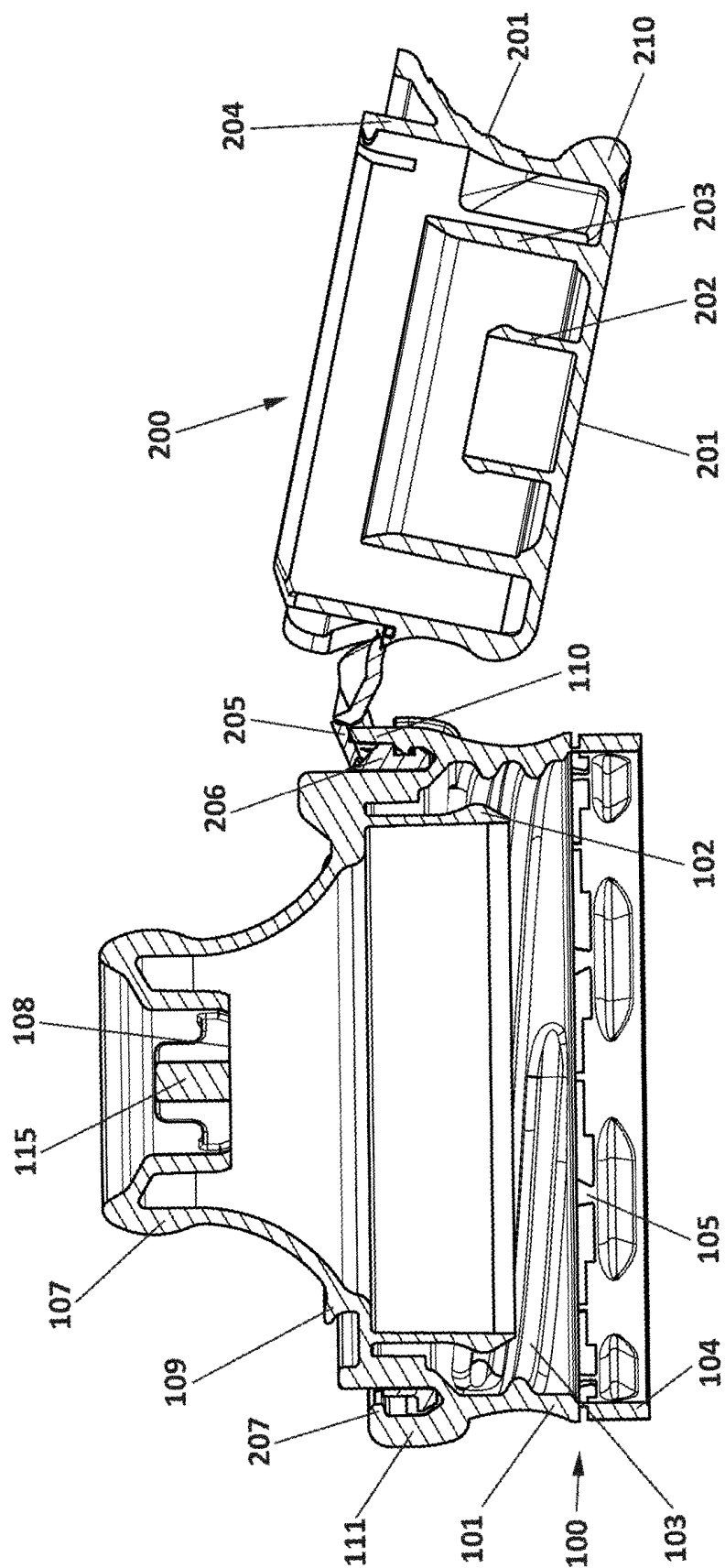


Fig. 13

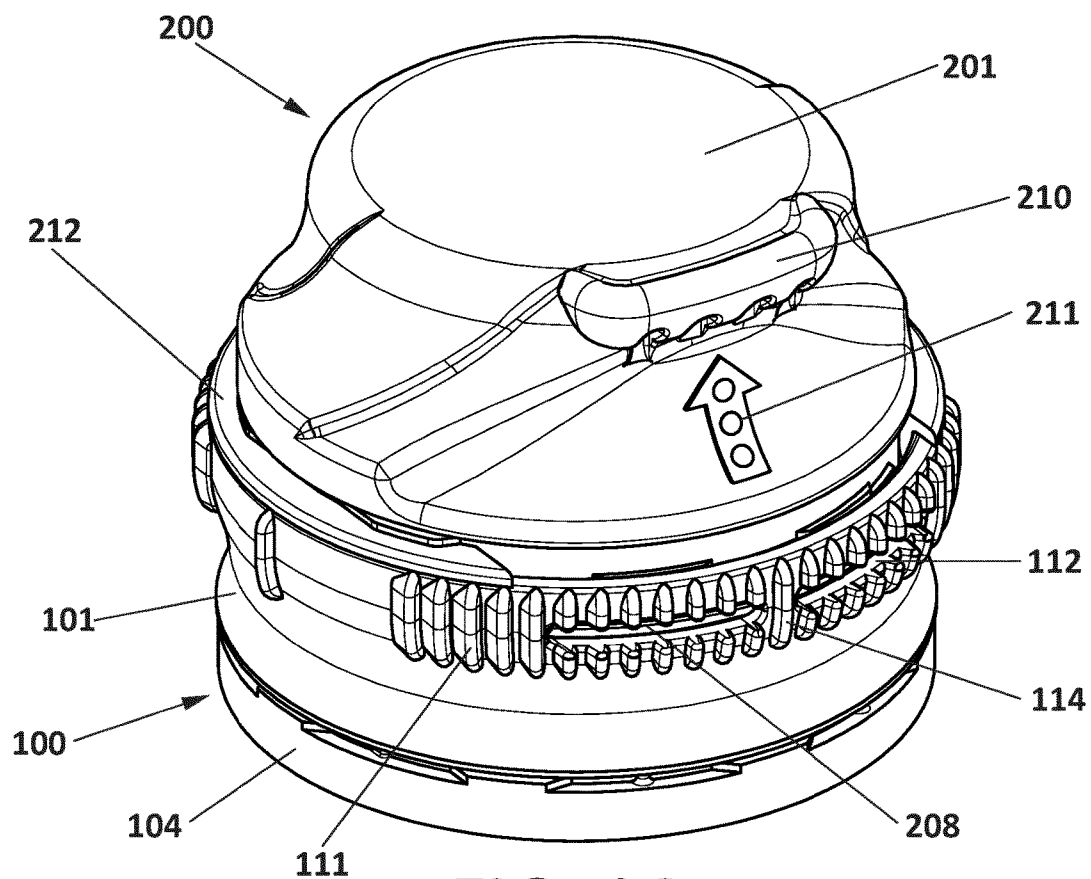


FIG. 14

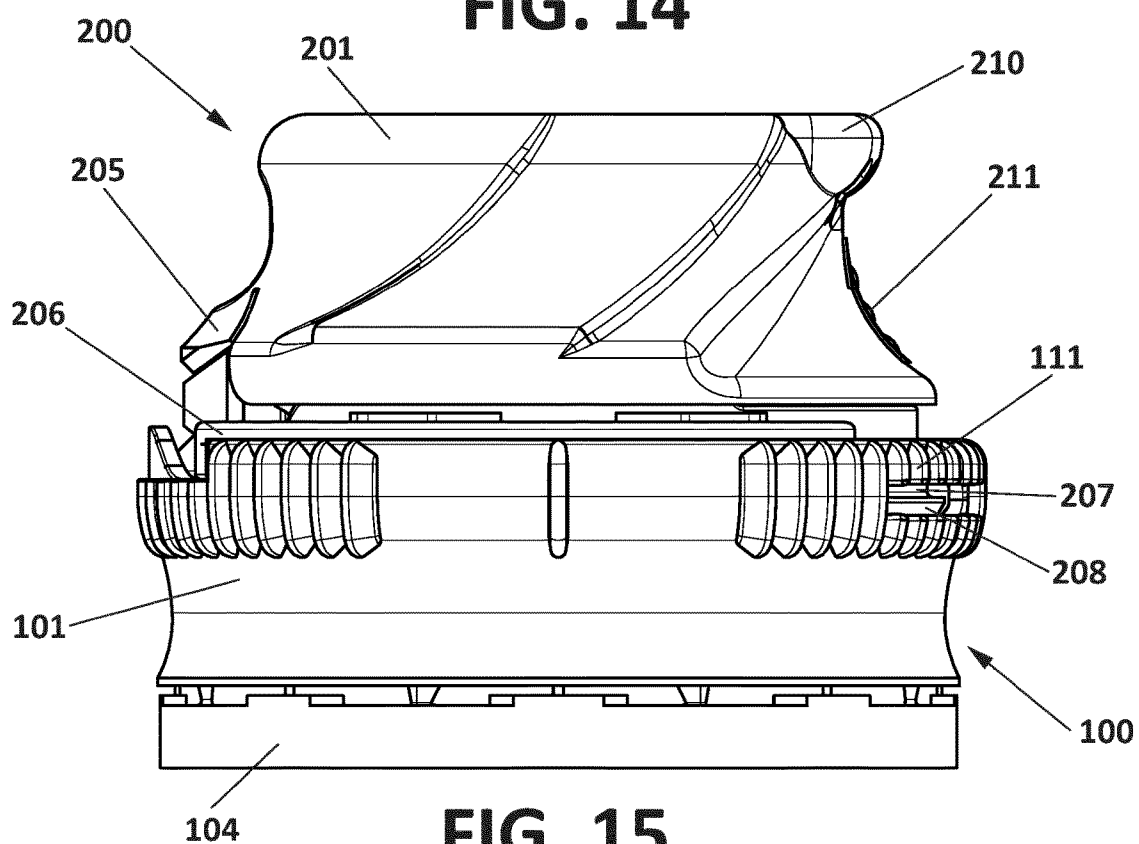


FIG. 15

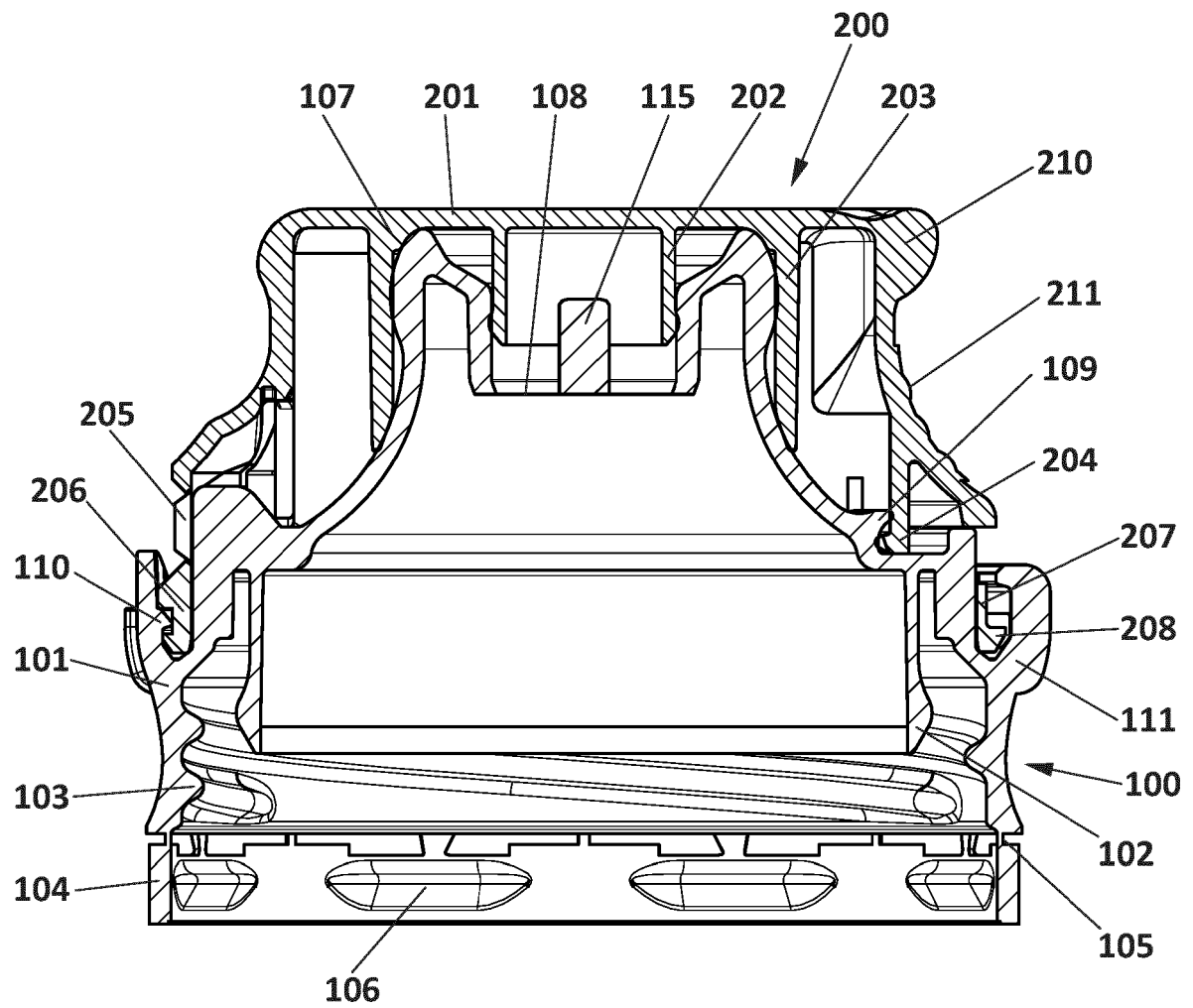


FIG. 16

REFERENCES CITED IN THE DESCRIPTION

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